SHIP ASK

# Work Order ID 72521

Thursday, July 28, 2011 9:16:47 AM



Page 1

Item ID: Revision ID:	D3531-041		Accept				s	etup Star	t	
Item Name:	Bracket Assembly							Sto	р	
Start Date: Required Date: Reference:	7/28/2011 Start Qty: 7.0 Req'd Qty: 7.0			Cust Item II Customer:	<b>D:</b>					1
Approvals:	Process Plan:	Date: /207-28	Tooling:	Da	ite:		R	tun Stai	t	
`	QC:	Date:	SPC (Y/N):		ite:			Sto	P	
Sequence ID/ Work Center ID	Operation Description		Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
Draw Nbr	Revision Nbr									
D3531	Rev A	   								•
Small Fab	Small Fab <b>Mem</b> o Assemb	ole as per dwg D3531	0.00 0.00 SB	162/0	3	,	7	)		
	Y.						A **			
QC Quality Control	QC5- Inspect part co	ompleteness to step on W/O	0.00 Julos	sla			<del>(7)</del>	<u>.</u> .		
120	Plank Care by 10, 00	1 3 5 7) per OSI005 4 2	0.00							:

Powdercoat

Powder Coating

Memo

0.00

START TIME: 10:10pm 10:10pm FINISH TIME:

JOVEN TEMPERATURE:

X7 & Mul08/07

W/O:			V	VORK ORDER CHANG	ES ·				
DATE	STEP	PROC	EDURE CH	IANGE	Ву	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector
16			-					L	11.08.09
Part No	<u>)</u>	3531-04/ PAR #: 1	_ Fault Ca	tegory: SMALL FAS	NCR Y	s No DO	2A: /	Date: _	9A462011
BARH	Б	esolution: SCRAP-		ion: SCRAP.			V/	Date: <u>\</u>	10810
Ner: 7	2521	W	ORK OR	DER NON-CONFORMA	NCE (N	CR)	\$6.60	1	
DATE	STEP	Description of NC Section A	Initial Chief Eng	Corrective Action Section Action Description Chief Eng		n& ∣ <sub>Sec</sub>	i <b>cation</b> ction C	Approval Chief Eng	Approval QC Inspector
11(08/03	[60]	is swap lote our	1.08.03	SCRAP PRE	SAS	g/23 S	`	Lange	2
		R.C. PROCESS.	G5104Z			ul	ods	11.08.03	nloslos
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## Work Order ID 72521

Thursday, July 28, 2011 9:16:48 AM



Page 2

Item ID:

D3531-041

Accept

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Setup Start



**Revision ID:** 

Item Name:

Bracket Assembly

**Start Date:** 

7/28/2011

QC:

Start Qty: 7.00

Required Date: 8/3/2011 Req'd Qty: 7.00

Date: \_\_\_\_\_

**Cust Item ID:** 

**Customer:** 

Reference:

Approvals:

Process Plan:

Date:

**Tooling:** 

SPC (Y/N):

Date:

Date:

Run Start

Stop

Stop



Sequence ID/ Work Center ID

130

Quality Control

Operation Description

QC3- Inspect Part Finish

Memo

Set Up/ **Run Hours** 

0.00

0.00

Tool ID

Tool # Plan

Accept Code Qty

Reject Qty

Reject Number

Insp. Stamp

140

Packaging

Packaging

Identify as per dwg & Stock Location:

0.00

Memo

150

Quality Control

QC21- Final Inspection - Work Order Release

0.00

Memo

0.00

W/O:			WO	RK ORDER CHANGE	S				e - , , , , , ,
DATE	STEP	PRO	OCEDURE CHAN	IGE	Ву	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector
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Part No		PAR #:	Fault Categ	ory:	NCR: Yes	No DQ	<b>\</b> :	_ Date: _	
	Re	esolution:	Disposition	:	QA: N/C Cld	sed:		Date:	
NCR:			WORK ORDE	R NON-CONFORMA	NCE (NCR	)			
DATE	STEP	Description of NC		Corrective Action Section		Verific	ation	Approval	Approval
DAIL	SIEF	Section A	Initial Chief Eng	Action Description Chief Eng	Sign & Date	Section		Chief Eng	QC Inspector
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Thursday, July 28, 2011 9:16:54 AM

Work Order ID: 72521

Parent Item:

D3531-041

Parent Item Name:

Bracket Assembly



Start Date: 7/28/2011

Required Date: 8/3/2011

Start Qty: 7.00

Required Qty: 7.00

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IPP Rev:A New Issue 07-09-24 EC verified DD

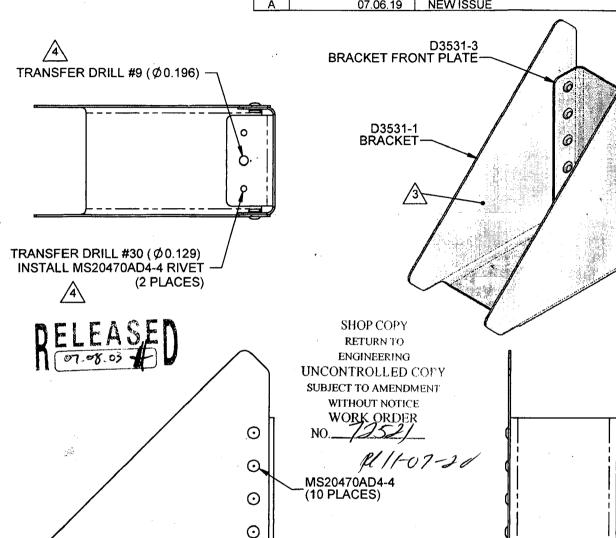
T/ NT	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
D3531-1  Bracket		Manufactured	No			100 B	Each 7 27	0.0000	1   <b>           </b>	7 	is 11/2	863	
D3531-3  Bracket Front Plate		Manufactured	No			100	Each p 7 (9	0.0000 78	1	7	B 116	163	.i
MS20470AD4-4  Rivet, Universal Head		Purchased	No			100	Each	1,060.000	12	84 S/3	((6	toz	
				<u>Location</u> ST139		Loc (	<u>Oty</u> 518	Loc Code			_		. 1 

<b>Location</b>		Loc Qty	Loc Code	
ST139		518		
1	117423	518		84
ST319		542		
. 1	116188	476		
1	116391	66		

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W/O:			W	ORK ORDER CHANG	ES	,			· •
DATE	STEP	PRO	OCEDURE CH	ANGE	Ву	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector
Part No	•	PAR #:	Fault Cate	egory:	_ NCR: Yes	s No DQ	<b>A</b> :	Date: _	
	, R	esolution:	Dispositi	on:	_ QA: N/C	Closed:		Date: _	·
NCR:			WORK ORE	DER NON-CONFORMA	ANCE (NO	R)			• •
DATE	STEP	Description of NC		Corrective Action Section		Verific	cation	Approval	Approval
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DESIG	B	DRAWN BY	DART AEROSPACE HAWKESBURY, ONTARIO, CAI	
CHECK	KED .	APPROVED	D3531	REV. A SHEET 1 OF 3
DATE	07.0	06.19	BRACKET ASSEMBLY	SCALE 1:2
REV		DATE	DESCRIPTION	



### D3531-041 BRACKET ASSEMBLY

0

NOTES:
1) FINISH: POWDER COAT ASSEMBLY BLACK SANDTEX (4.3.5.7) PER DART QSI 005 4.3

**ALL PARTS** 

2) ASSEMBLE PER DART QSI 003

3) IDENTIFY WITH DART P/N "D3531-041" USING WHITE MARKER ON INSIDE OF BRACKET ASSEMBLY, WHERE, INDICATED

4) TRANSFER DRILL HOLES FROM D3531-1 BRACKET THROUGH, D3531-3 BRACKET FRONT PLATE BEFOREIFINISHING

#### **PARTS LIST**

X         D3531-041         BRACKET ASSEMBLY           1         D3531-1         BRACKET           1         D3531-3         BRACKET EPONT DI AT	QTY.	P/N	DESCRIPTION
	Х	D3531-041	BRACKET ASSEMBLY
1 D3531-3 BRACKET FRONT DI AT	1	D3531-1	BRACKET
Possi-s   Dissort i Kolti FEAT	1	D3531-3	BRACKET FRONT PLATE
	12	MS20470AD4-4	RIVET

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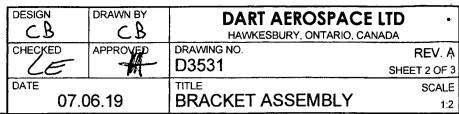
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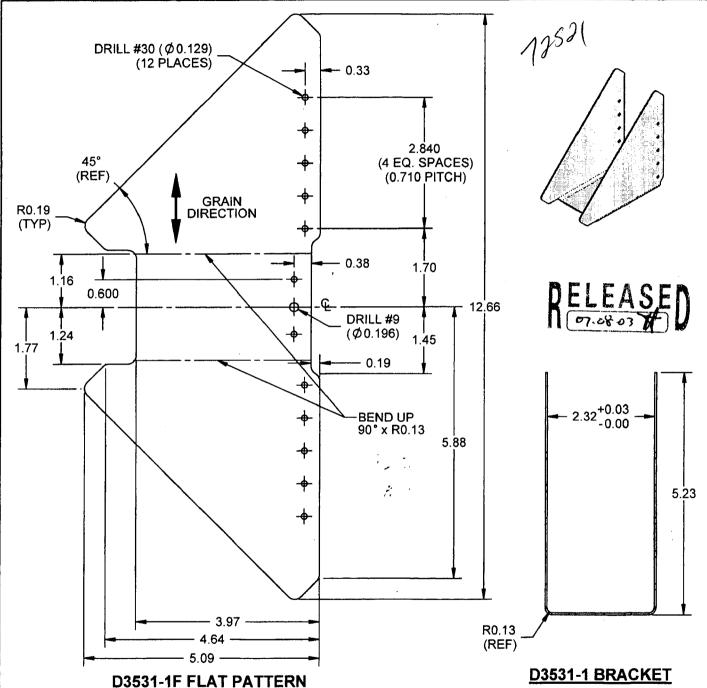
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W/O:			WORK ORDER	CHANGES		•		
DATE	STEP	PRO	OCEDURE CHANGE	В	y Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector
Part No	:	PAR #:	Fault Category:	NCR: \	es No DC	A:	Date: _	
	Resolution:		Disposition:	QA: N/	C Closed:		Date: _	
NCR:		,	WORK ORDER NON-CON	IFORMANCE (N	ICR)			
	_		Corrective Action	n Section B			T	

NCR:			WORK ORDI	ER NON-CONFORMANO	CE (NCR)			
DATE	OTED	Description of NC		Corrective Action Section B		Verification	Approval	Approval QC Inspector
DATE	STEP	Section A	Initial Chief Eng	Action Description Chief Eng	Sign & Date	Section C	Chief Eng	
,								







#### NOTES:

- 1) MATERIAL: ALUMINUM 6061-T6/T62 SHEET, 0.040 THICK PER QQ-A-250/11 OR AMS 4025 OR AMS 4027 (REF DART SPEC M6061T6S.040)
  2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) ALL DIMENSIONS ARE IN INCHES UNLESS OTHERWISE NOTED
  5) BREAK ALL SHARP CORNERS TO 0.010 MAX
  6) PART IS SYMMETRIC ABOUT Q.

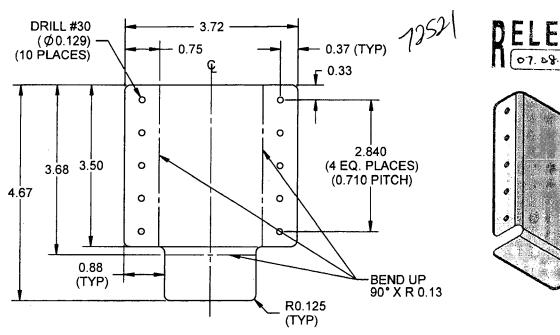
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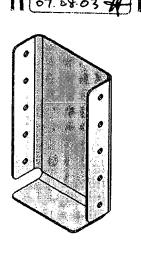
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Part No	:	PAR #:	Fault Categ	jory:	_ NCR: Yes	No <b>DQ</b>	A:	Date: _		
			Disposition: Q						Date:	
NCR:			WORK ORDE	R NON-CONFORMA	NCE (NCR	)		.,	- · · · · · · · · · · · · · · · · · · ·	
DATE	STEP	Description of NC Section A	Corrective Action Section		on B	Verification		Approval	Approval	
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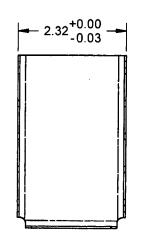


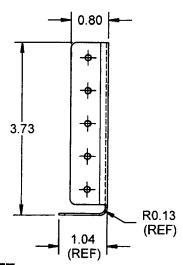
DESIGN	DRAWN BY	DART AEROSPACE LTD  HAWKESBURY, ONTARIO, CANADA			
CHECKED	APPROVED	DRAWING NO.	REV. A SHEET 3 OF 3		
DATE 07.	06.19	BRACKET ASSEMBLY	SCALE 1:2		





## **D3531-3F FLAT PATTERN**





## **D3531-3 BRACKET FRONT PLATE**

- NOTES:
  1) MATERIAL: ALUMINUM 6061-T6/T62 SHEET, 0.040 THICK PER QQ-A-250/11 OR AMS 4025 OR AMS 4027 (REF DART SPEC M6061T6S.040)
  2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED 4) ALL DIMENSIONS ARE IN INCHES UNLESS OTHERWISE NOTED
- 5) BREAK ALL SHARP CORNERS TO 0.010 MAX
- 6) PART IS SYMMETRIC ABOUT Q

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		W							
Part No:		PAR #:	Fault Category:		NCR: Yes No DQA: Date				
		esolution:							
NCR:			WORK ORE	DER NON-CONFORMA	NCE (NCF	1)		,	
DATE	STEP	Description of NC Section A		on B	Verification		Approval	Approval	
			Initial Chief Eng	Action Description Chief Eng	Sign & Date		ion C	Chief Eng	QC Inspector
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